

Date: Monday, 19/11/2007 2:23:36 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 35704		
Estimate Number	: 10762		
P.O. Number	: <i>N/A</i>	Part Number	: D33409
This Issue	: 19/11/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3340 REV B
Prst Rev.	: NC	Project Number	: N/A
First Issue	: 13/11/2007 Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 25191	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 30/11/2007 Qty: 12 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est: 05.11.10 Preliminary issue AP/EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M1010S19GA

1010/1025/A21/6aA SHEET .040



Comment: Qty.: 0.9339 sf(s)/Unit Total : 11.2064 sf(s)
 1010/1025/A21/6aA SHEET .040

(M1010S19GA) *20GA* SEE W/D CHG *07.12.10*
 Batch: *106478* *18 07-12-12*

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3340

Dwg Rev: *B*Prog Rev: *B**18 07-12-12**(12)*

2-Deburr if necessary

18 07-12-12

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

*18 07-12-12*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5 *10000*
07/12/12 *(12)*

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr is necessary

Form on brake as per Dwg D3340

SB *07/12/12* *(12)*

Date: Monday, 19/11/2007 2:23:36 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 35704

Part Number: D33409

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/12/12 (X12) count

7.0

POWDER COATING

POWDER COATING



M 10 S 642



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

12X
M-1 07/12/13

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-12-13 (X12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST498

AS 07/12/13 (X12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/12/14

Job Completion



U 07-12-14

Date: Tuesday, 11/13/2007 1:34:05 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD
Job Number : 35704	
Estimate Number : 10762	
P.O. Number :	Part Number : D33409
This Issue : 11/13/2007 S.O. No. :	Drawing Number : D3340 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 25191	Material :
Written By : <u>[Signature]</u>	Due Date : 11/30/2007 Qty: 12 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est: A 05.11.10 Preliminary issue AP/EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: _____

Email of ship DXF file to vendor

Laser Cut per Dwg D3340 flat pattern D3340-9

Material release note required

W. H. F. 12/1/07
Est done

2.0	D33409F	Wearplate
-----	---------	-----------



Comment: Qty.: 1.0000 U(s)/Unit Total : 12.0000 U(s)
Wearshoe

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material release note is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions

5.0	BRAKE NC	NC BRAKE
-----	----------	----------

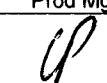


Comment: NC BRAKE

Deburr is necessary

Form on brake as per Dwg D3340 using Jigs DT and DT

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.12.10	1	USE M10105206A INSTEAD OF M10105196A				 07.12.10 824 051 042	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/13/2007 1:34:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 35704

Part Number: D33409

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

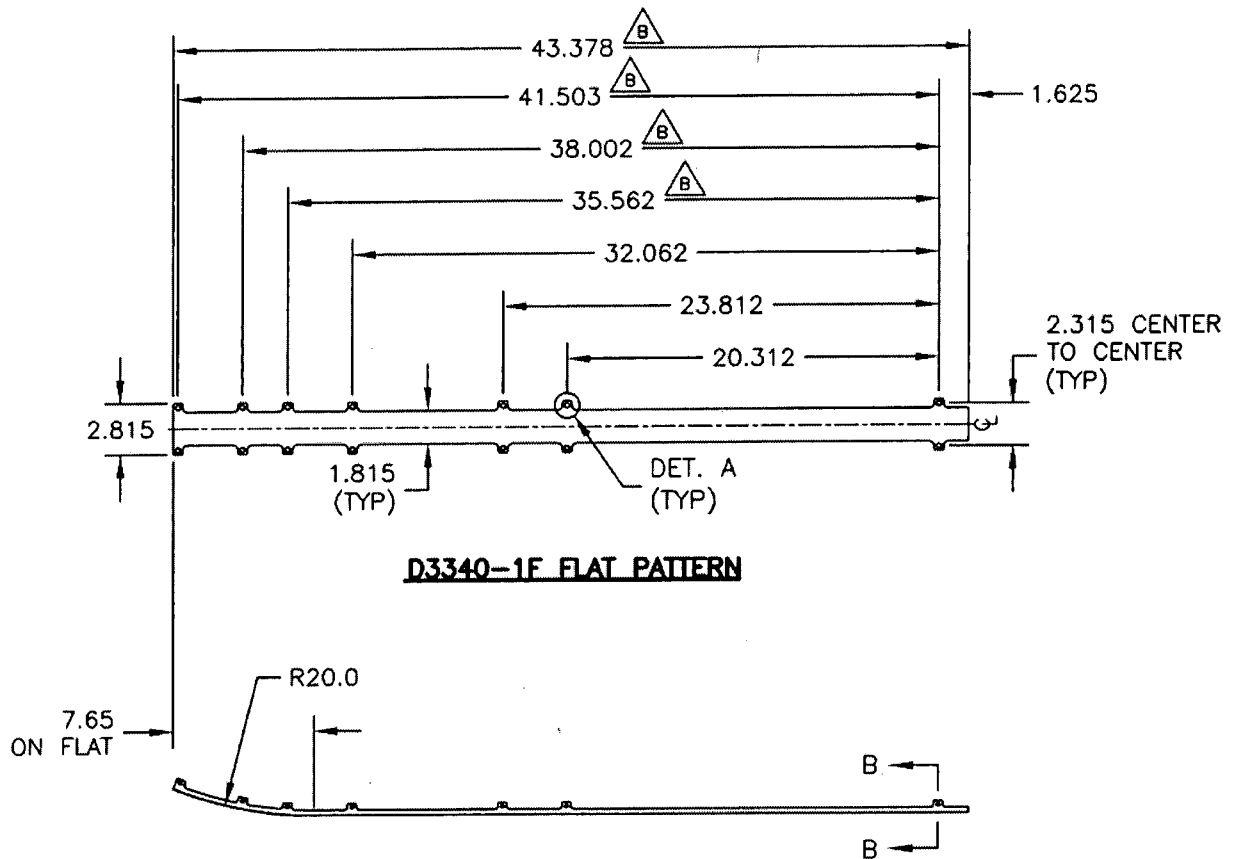
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10
A	05.06.09	NEW ISSUE	
B	05.11.22	ADD DETAIL D, CORRECT FLAT PATTERNS D3340-1/-3/-7/-9/-13/-19/-23	

RELEASED
05.11.28



D3340-1F FLAT PATTERN

D3340-1 FORWARD SKIDTUBE PROTECTOR

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

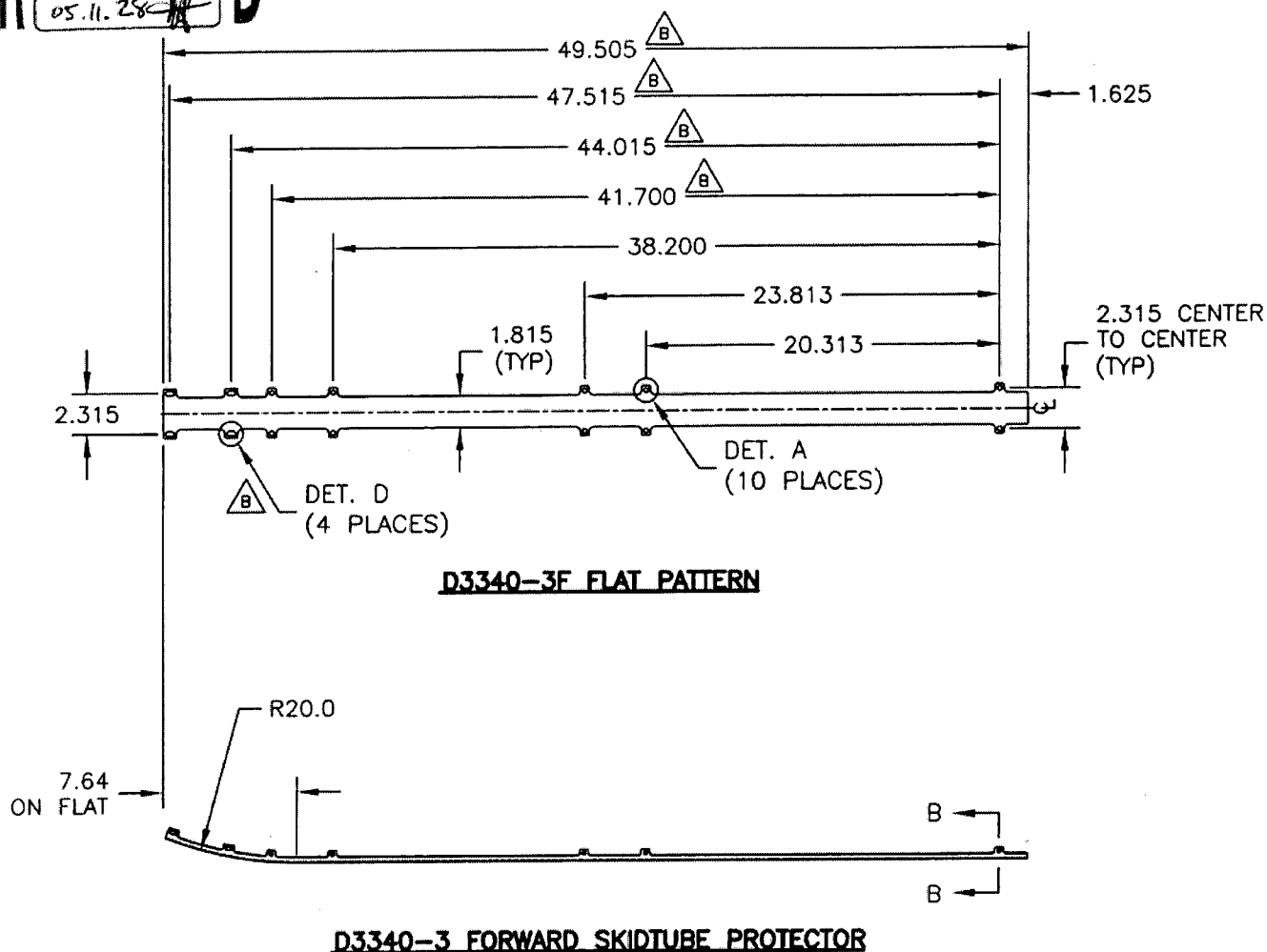
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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10

RELEASED
05.11.22**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 0051403
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

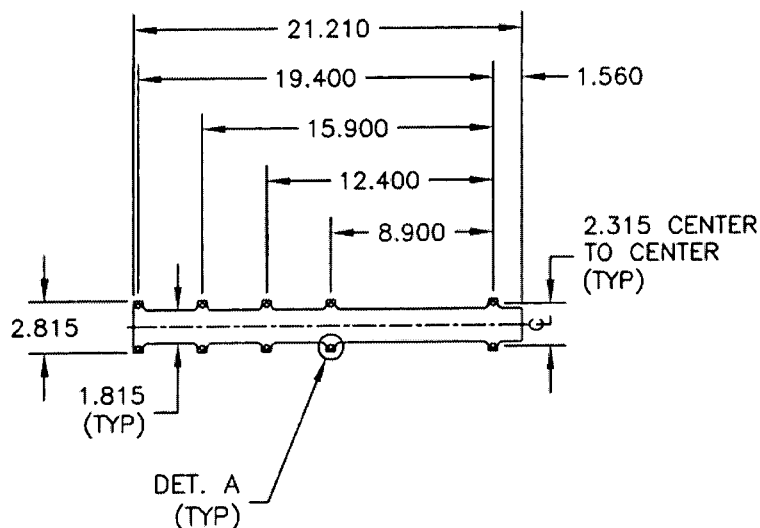
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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10

RELEASED
05.11.28 *[Signature]***D3340-5F FLAT PATTERN****D3340-5 FORWARD SKIDTUBE PROTECTOR****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 N4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

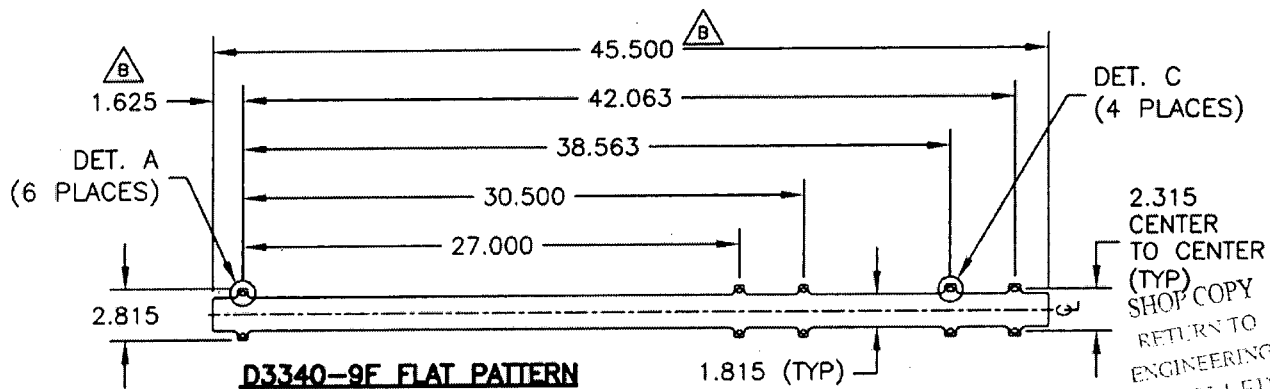
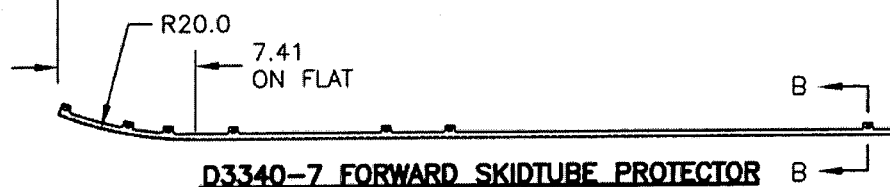
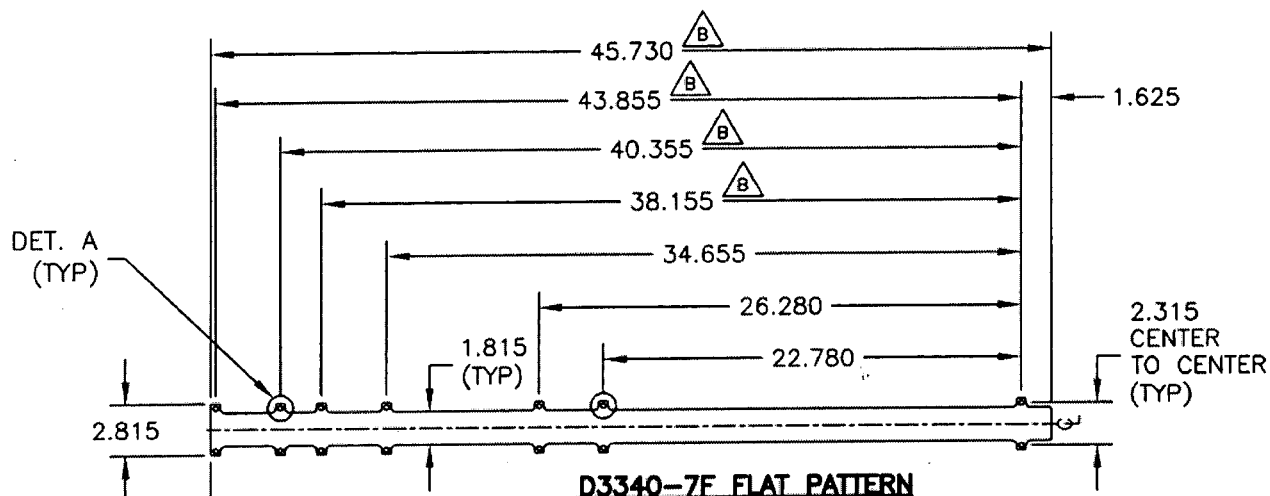
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DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10



D3340-9 AFT SKIDTUBE PROTECTOR

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

RELEASED
05.11.28

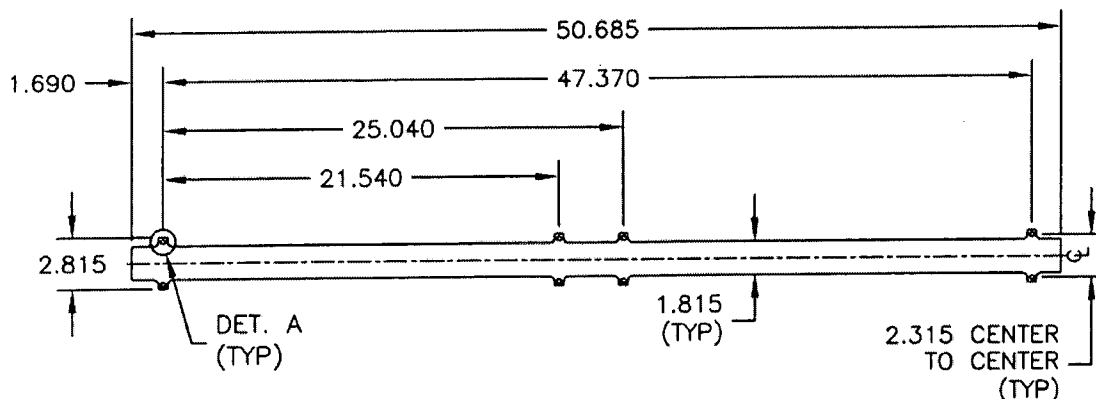
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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10

RELEASED
05.11.28



D3340-11F FLAT PATTERN



D3340-11 CENTER SKIDTUBE PROTECTOR

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR
ASTM A36/A366/A1008 OR
CSA G40-21, 38W/44W/50W/60W/70W SERIES
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6)
PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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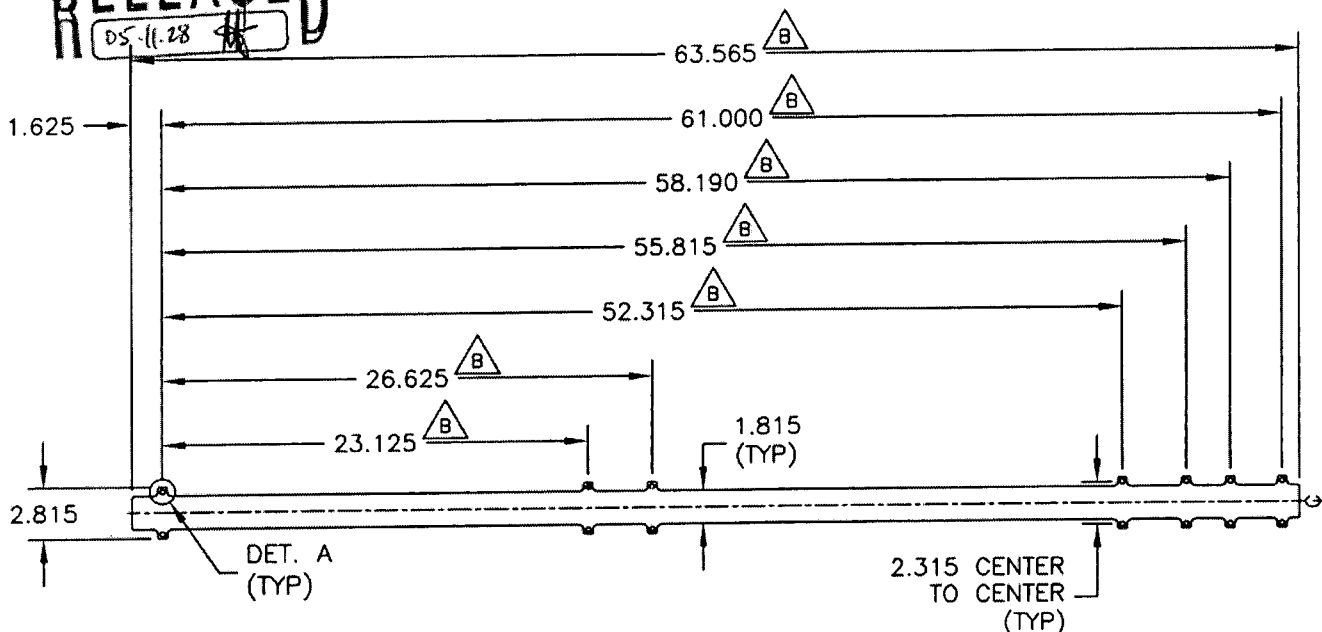
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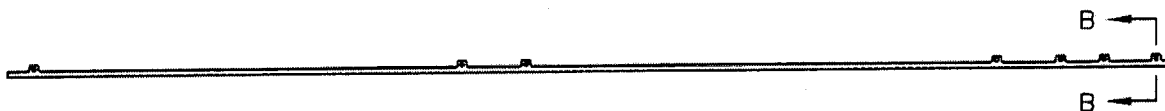


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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10

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05.11.28



D3340-13F FLAT PATTERN



D3340-13 AFT SKIDTUBE PROTECTOR

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005.43
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

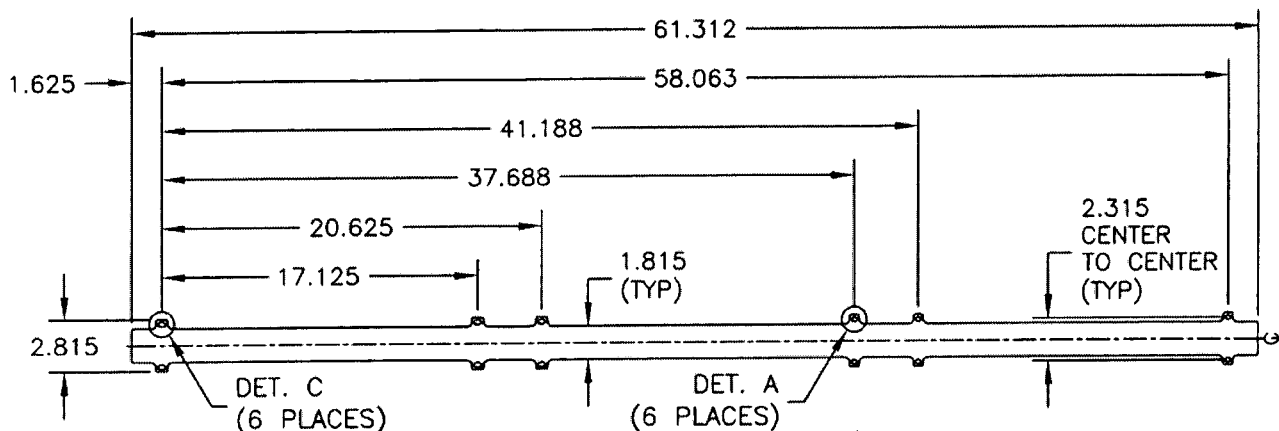
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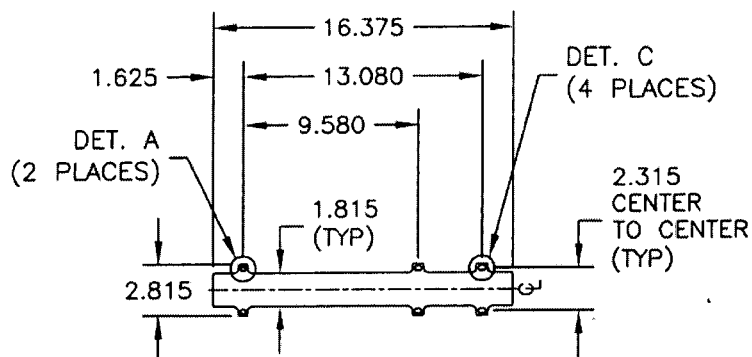
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DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10



D3340-15F FLAT PATTERN

RELEASED
05.11.22 [Signature]

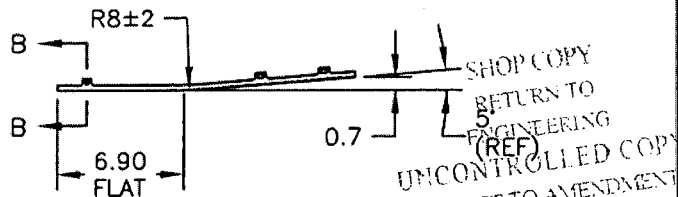
D3340-15 CENTER SKIDTUBE PROTECTOR



D3340-17F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX



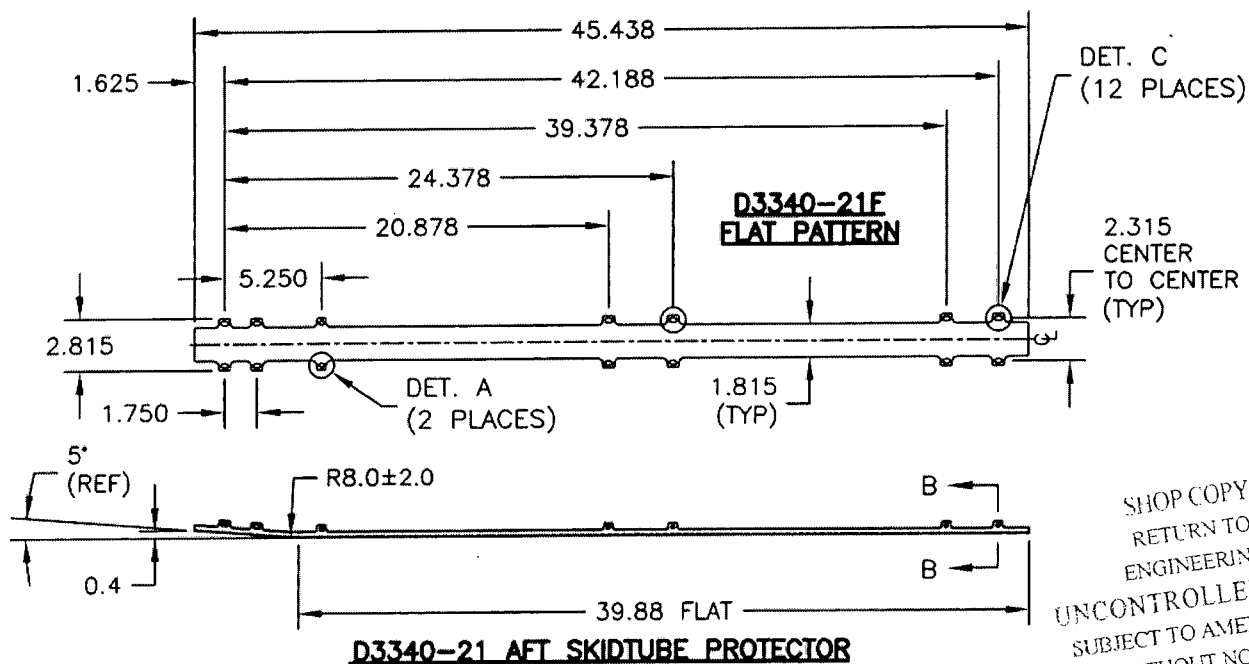
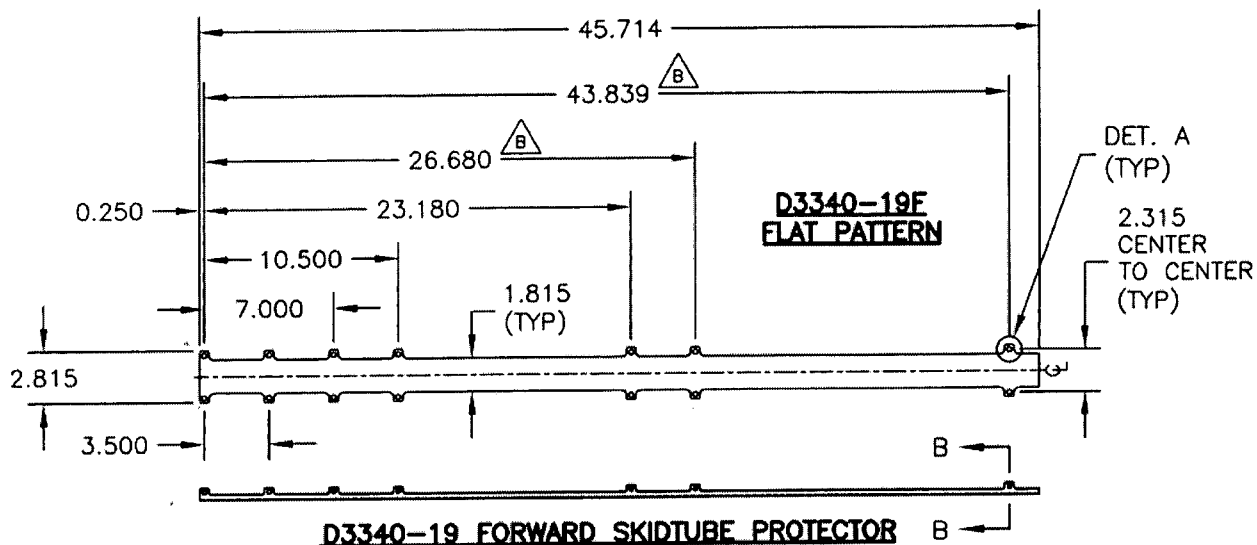
D3340-17 AFT SKIDTUBE PROTECTOR

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CHECKED 	APPROVED 	DRAWING NO. D3340	REV. B SHEET 8 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W—
SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

RELEASED
05.11.28

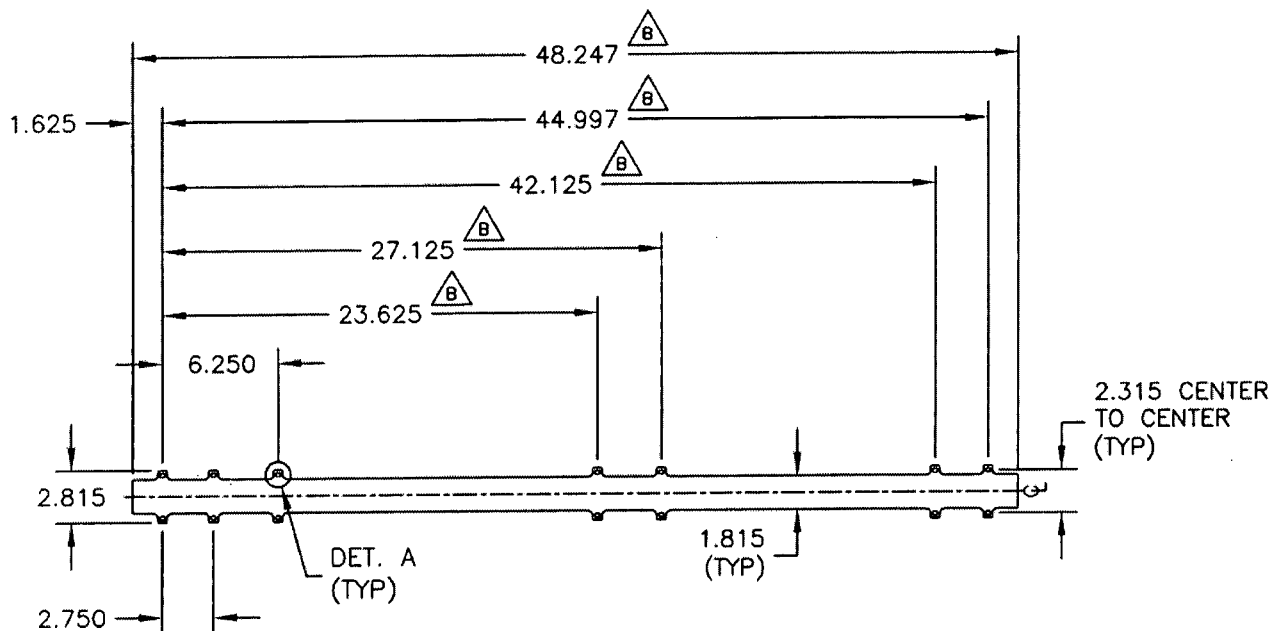
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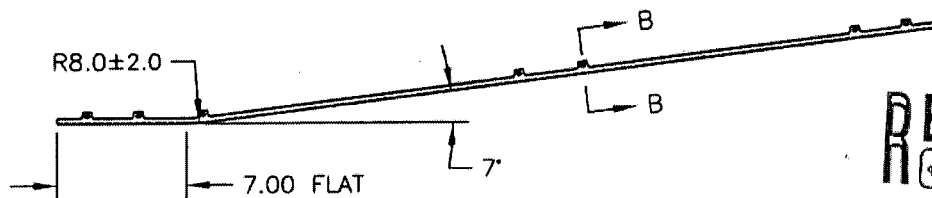
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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10



D3340-23F FLAT PATTERN



D3340-23 AFT FLOAT SKIDTUBE PROTECTOR

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR
ASTM A36/A366/A1008 OR
CSA G40-21, 38W/44W/50W/60W/70W SERIES
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6)
PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

RELEASED
05.11.28 *[Signature]*

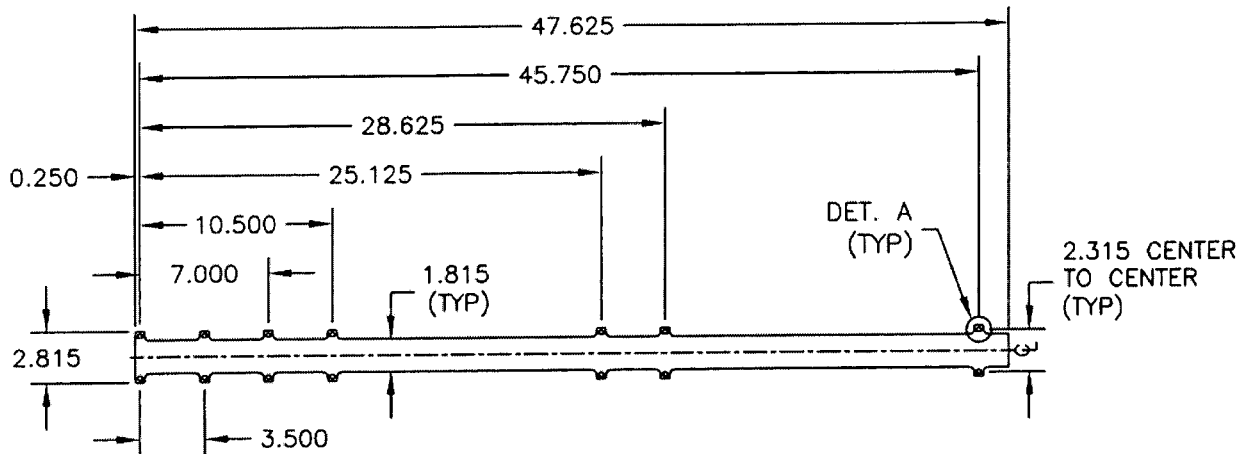
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DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10



D3340-25F FLAT PATTERN

RELEASED
05.11.28 *[Signature]*



D3340-25 FORWARD SKIDTUBE PROTECTOR

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR
ASTM A36/A366/A1008 OR
CSA G40-21, 38W/44W/50W/60W/70W SERIES
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6)
PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

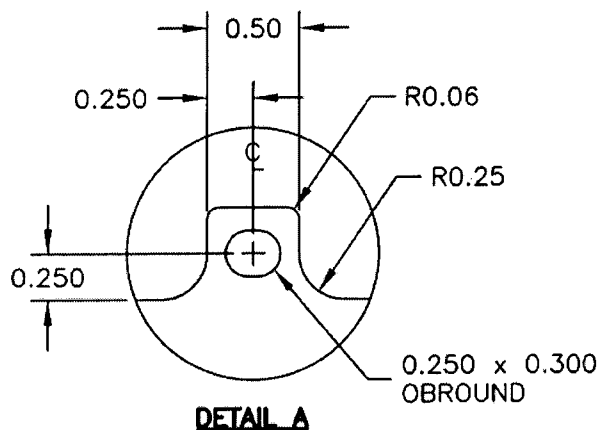
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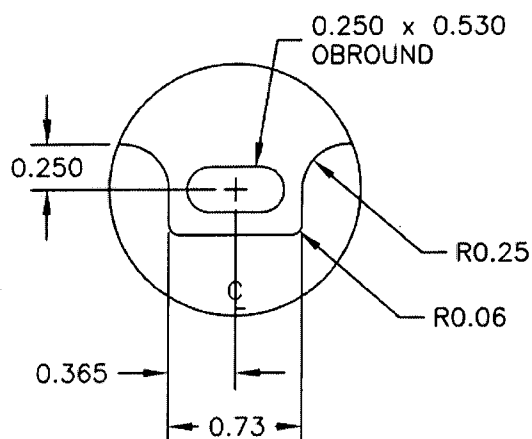
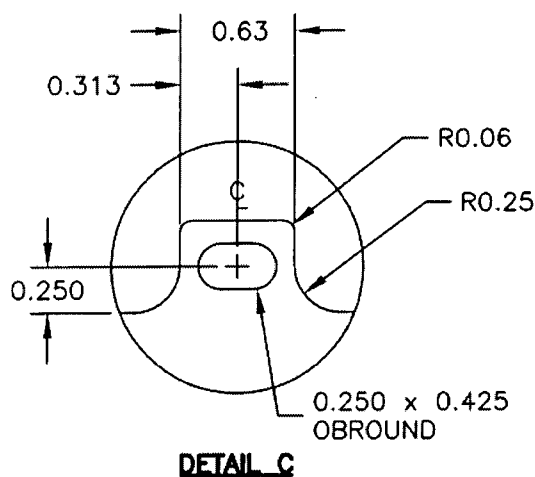
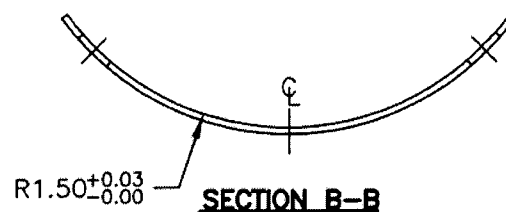
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